

Work Order ID 64114

Wednesday, November 24, 2010 2:29:27 PM



Page 1

Item ID: D3531-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 11/25/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: umf Date: 10-11-24 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	Rev A

100 Small Fab 0.00



Small Fab Memo 0.00

Small Fab Assemble as per dwg D3531

ES 10/12/21 (3)

110 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8/10/12/21

(X3)

120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00



Powdercoat Memo 0.00

Powder Coating

16/11/25/88

START TIME: 7:25 OVEN TEMPERATURE:

FINISH TIME: 8:00

3 11-01-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64114

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 181

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-01-04

Picklist Print

Wednesday, November 24, 2010 2:29:26 PM

Page 1

Work Order ID: 64114

Parent Item: D3531-041

Parent Item Name: Bracket Assembly




Start Date: 11/25/2010

Required Date: 12/9/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1  Bracket		Manufactured	No			100	Each	0.0000	1	3			
D3531-3  Bracket Front Plate		Manufactured	No			100	Each	1.0000	1	3			
<div> <div>Location</div> <div>ST068</div> <div>61781</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS20470AD4-4  Rivet, Universal Head		Purchased	No			100	Each	3,878.000	12	36			
<div> <div>Location</div> <div>ST319</div> <div>112314</div> <div>113368</div> <div>115470</div> <div>116188</div> </div> <div> <div>Loc Qty</div> <div>3878</div> <div>30</div> <div>92</div> <div>756</div> <div>3000</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

B64115 (3x)



EP510/12/21



EP510/12/21

B64116 (2x)



EP510/12/21

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

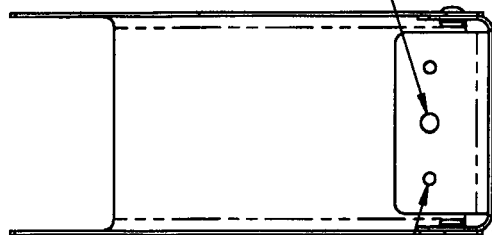
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

△
TRANSFER DRILL #9 (Ø0.196)



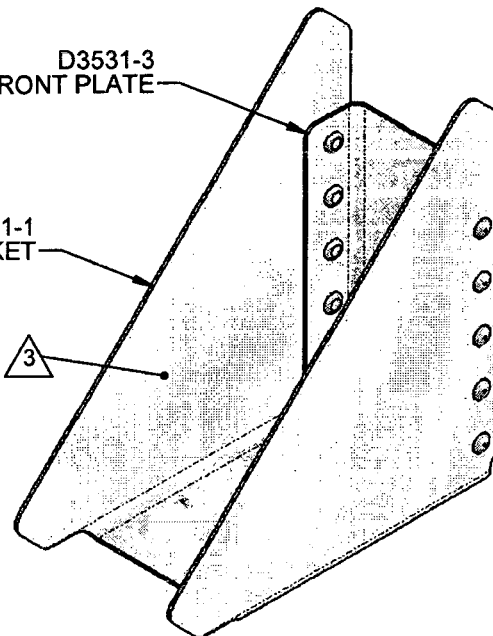
TRANSFER DRILL #30 (Ø0.129)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)



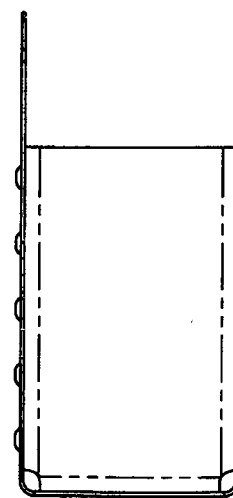
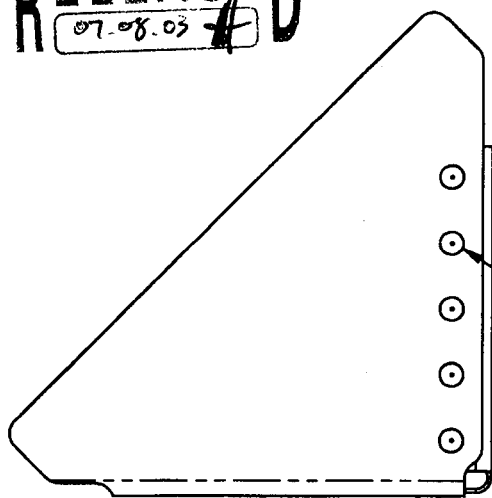
RELEASED
07-08-03

D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET



MS20470AD4-4
(10 PLACES)



64114

D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

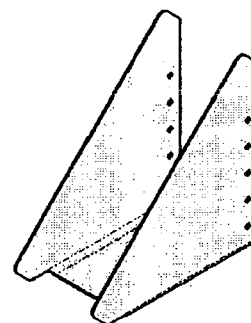
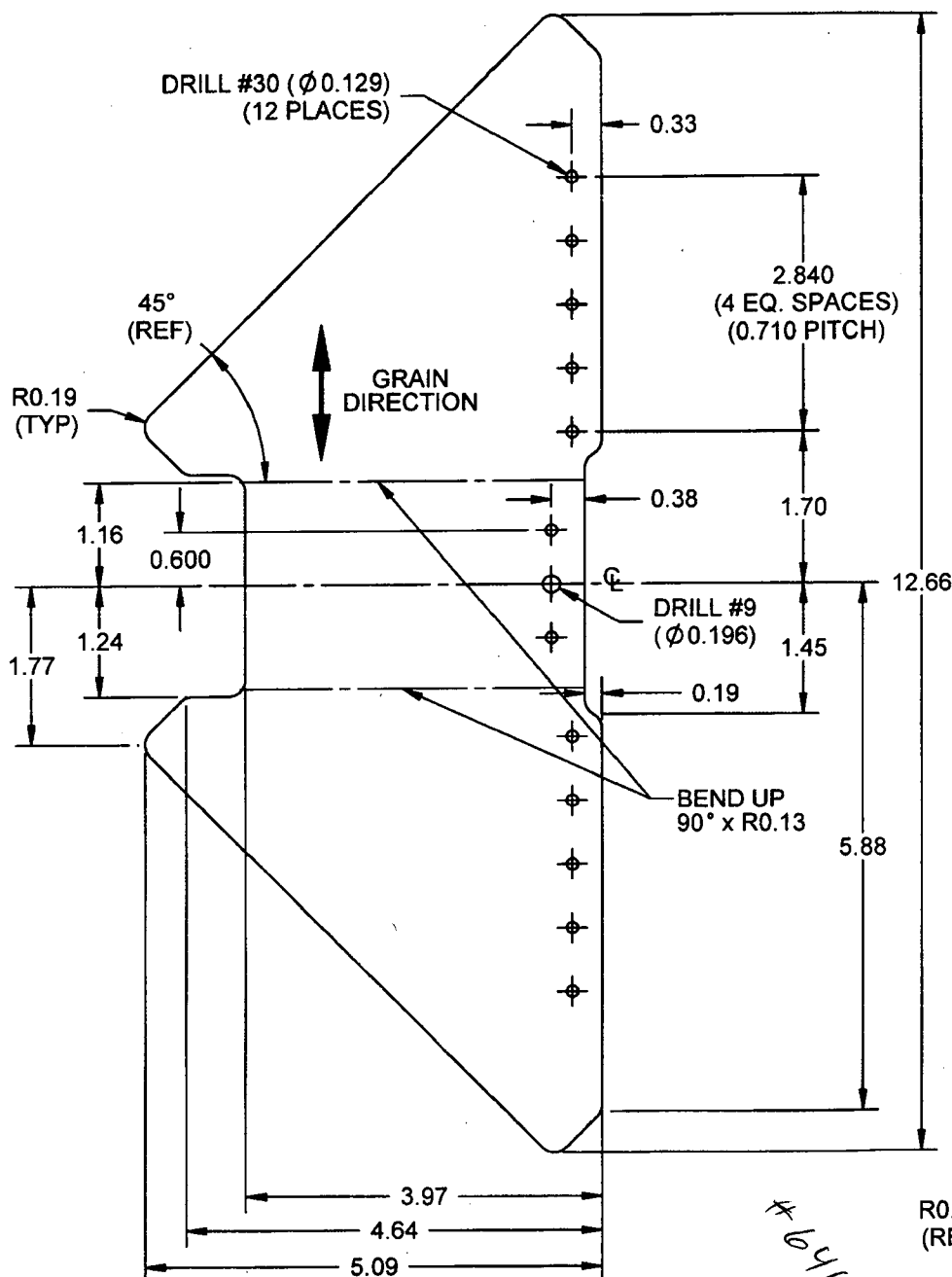
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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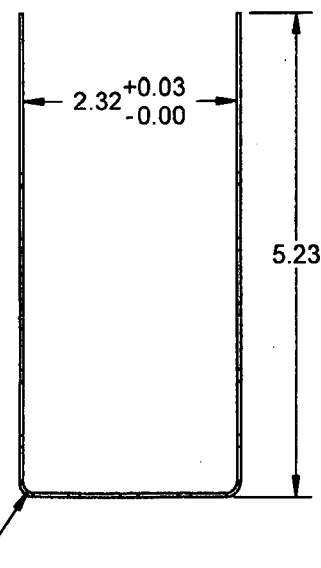
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED HA	DRAWING NO. D3531
DATE 07.06.19	TITLE BRACKET ASSEMBLY	REV. A SHEET 2 OF 3 SCALE 1:2



RELEASED
07-08-03



D3531-1F FLAT PATTERN

D3531-1 BRACKET

NOTES:

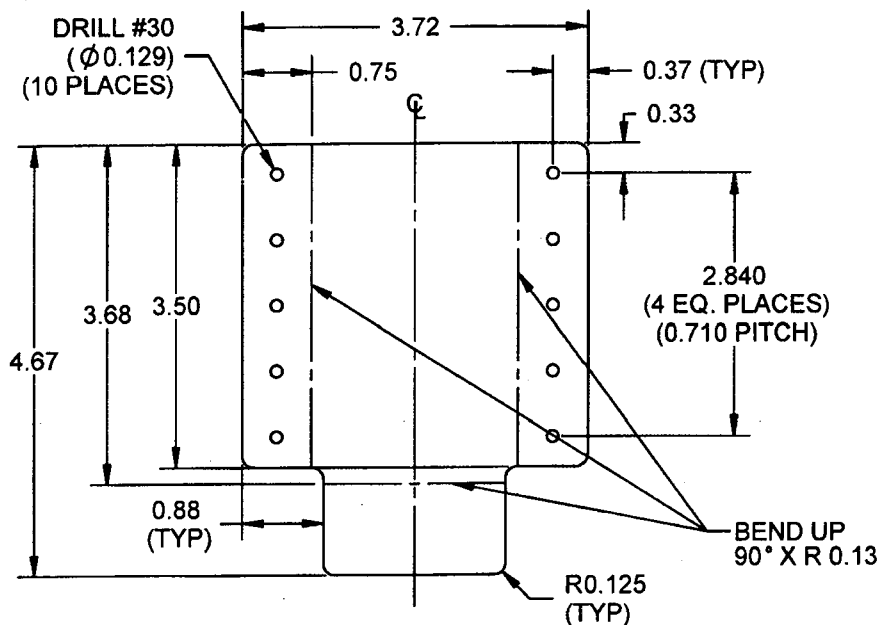
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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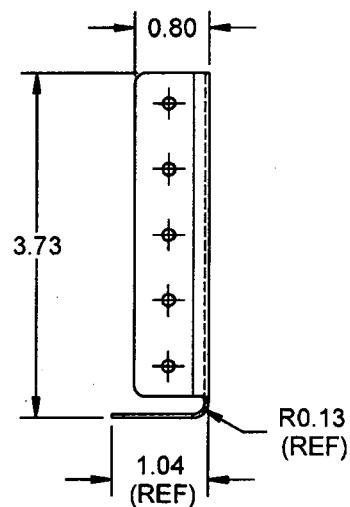
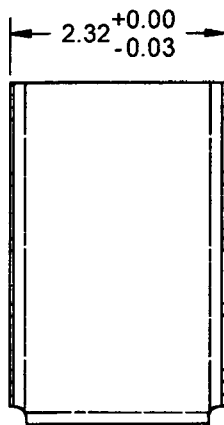


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED #	DRAWING NO. D3531
DATE 07.06.19	TITLE BRACKET ASSEMBLY	REV. A SHEET 3 OF 3 SCALE 1:2



D3531-3F FLAT PATTERN

RELEASED
07.08.03 #



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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